

Application No.: 10/734,047
Docket No.: AD7076 USNA

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Amendment to the Specification

Please amend Example 1 as follows:

Example 1

An extruder was modified so that the blowing pin, which was 360
30 mm in length, had a cooling jacket which extended 300 mm over
its length, such that the cooling jacket essentially covered the
entire area of the blow pin that is not inserted into the parison
during the blow molding process. A second modification to the
blow pin was made to provide a grooved channel on the outside of
the nozzle. Both heads of the extruder were modified so that the
polymers that were passed through the heads were subjected to
increased shear to eliminate gels in the extruded polymer. The
cooling fluid (water/glycol?) in the cooling jacket of the
blowing pin was lowered to -4°C . The mold of the blow molding
machine was modified so that the cooling channels in the mold
were nearer to the surface of the mold, relative to the normal
mold. The coolant flowing through the cooling channels of the
mold was maintained at 5°C ($\pm 1^{\circ}\text{C}$). The polymers (Surlyn® 8920
for the outer layer (available from E.I. DuPont de Nemours and
Co.) and PP 520 (available from Honam Petrochemical) were dried
according to the manufacturers specifications prior to feeding to
the extruders. The Surlyn® was heated to a temperature in the
range of 160°C to 180°C and the polypropylene heated to a
temperature in the range of 160°C to 170°C . The heads were both
maintained at a temperature in the range of 160°C to 180°C , and
the die temperature was 160°C . The blowing pin used an air
supply to blow air at a pressure of 3 to 5 kPa, and at a
temperature of from -5°C to 5°C . Surlyn® and polypropylene were
fed to the extruder and to the die in a weight ratio of 9:1. The
outer layer (Surlyn®) of the square container was transparent,
having a thickness of about 3.5 - 4.0 mm.